Dart Aerospace Ltd. Monday, 4/23/2007 1:52:40 PM Date: User: Kim Johnston **Process Sheet Drawing Name** : GASKET Customer : CU-DAR001 Dart Helicopters Services Job Number : 31994 **Estimate Number** : 12722 : N 1 : D353615 P.O. Number **Part Number** D3536 REV A : 4/23/2007 **Drawing Number** This Issue : N/A Prsht Rev. Project Number : SMALL /MED FAB First Issue Type **Drawing Revision** : 30753 Material Previous Run Qty: 20 Um: : 4/30/2007 Each **Due Date** Written By Checked & Approved By New Issue 07-02-14 JLM Comment : Est Rev:A **Additional Product** Job Number: Description: Seq. #: **Machine Or Operation:** NEOPRENE SHEET 0.063 1.0 MNEO60S063 Comment: Qty.: 1.0340 sf(s)/Unit Total: 20.6808 sf(s) **NEOPRENE SHEET 0.063** M103104 Batch: 2.0 WATER JET FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3536 Dwg Rev: \_\_\_\_\_ SAD 07/05/03 Prog Rev: 1 20 2-Deburr if necessary 3.0 INSPECT PARTS AS THEY COME OFF MACHINE QC2 SAD Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK PACKAGING 1 PACKAGING RESOURCE #1 5.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: _	PAR #:	Fault Category:	NCR: Yes/No	DQA:	Date: 07/05/07
¥			QA: N/C C	losed:	Date:

NCR:		W	ORK OR	DER NON-CONFORMANCE	E (NCR)			ï
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
07/05/03	7.0	a parts were Not in telence. Cutwithout a cover on the material		Scrap & destroy and replace	SA1)			
		a cover on the material	651042	2	01/03/	1070503	651042	070503
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NOTE: Date & initial all entries

Date:

Monday, 4/23/2007 1:52:40 PM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 31994

Part Number: D353615

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



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## Dart Aerospace Ltd

W/O:			WORK ORDER CHA	NGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31994
Description: Gasket	Part Number:	D3536-15
Inspection Dwg: D3536 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.14			M-T/Very	
35.65	+/-0.030	35.64			M-T/ver	h
33.65	+/-0.030	33,64			M-T/ver	
30.15	+/-0.030	30,15	/		M-T I ve	ru
24.90	+/-0.030	24.89	/		M-t/ver.	
19.65	+/-0.030	19.64	/		M-T-Ver	ำ
14.40	+/-0.030	14.39	/		M-T-/Ven	a
9.15	+/-0.030	9.141	/		Vern	•
5.65	+/-0.030	5.628	~		Vern:	
3.90	+/-0.030	3.89	~		Vern	
8.00	+/-0.030	7.98	~		Vern	
16.00	+/-0.030	16.62	~		M-t /very	
24.00	+/-0.030	24.012			M-T/Vern	
0.30	+/-0.030	0.312	<b>/</b>		Vern	
0.30	+/-0.030	0.315	/		Vern	
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Measured by:	SAD	Audited by:	Prototype Approval:	N/A
Date:	07/05/03	Date: -1.05.03	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.03.14	New Issue	KJ/JLM	

B. 52.12

26.65 23.15 21.15 17.65 13.40 - 0.90 9.15 5.65 1.89 3.90 ø0.19 (TYP 3 PLS)

D3536-11 GASKET

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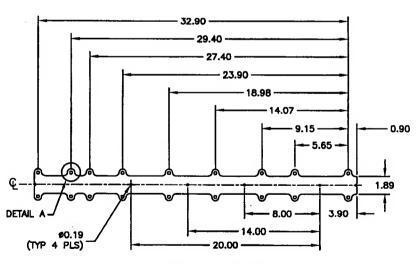
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PURPOSE

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
  3) PART IS SYMMETRICAL ABOUT 
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



**D3536-13 GASKET** 

06.10.25 NEW ISSUE	06.10.25	A
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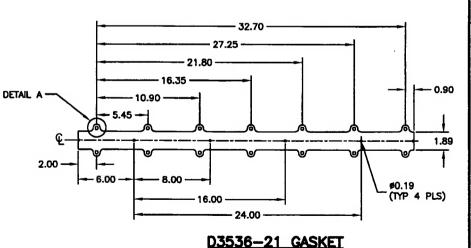
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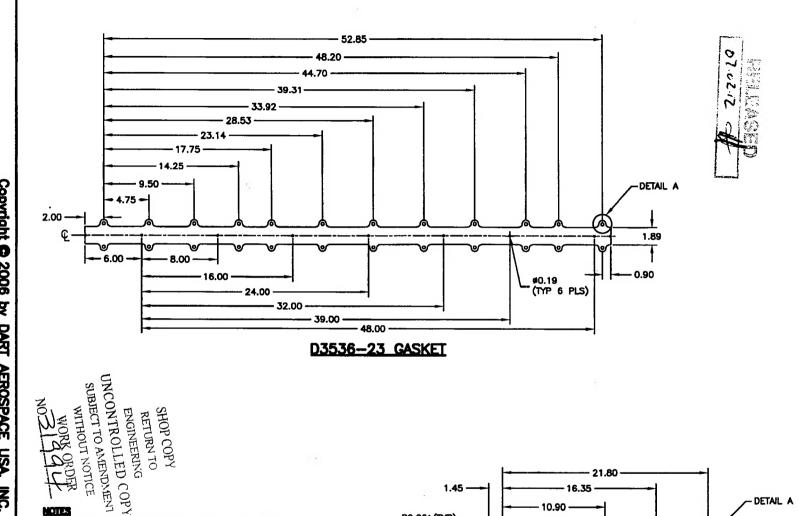


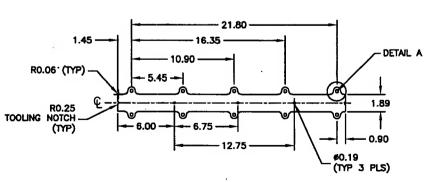
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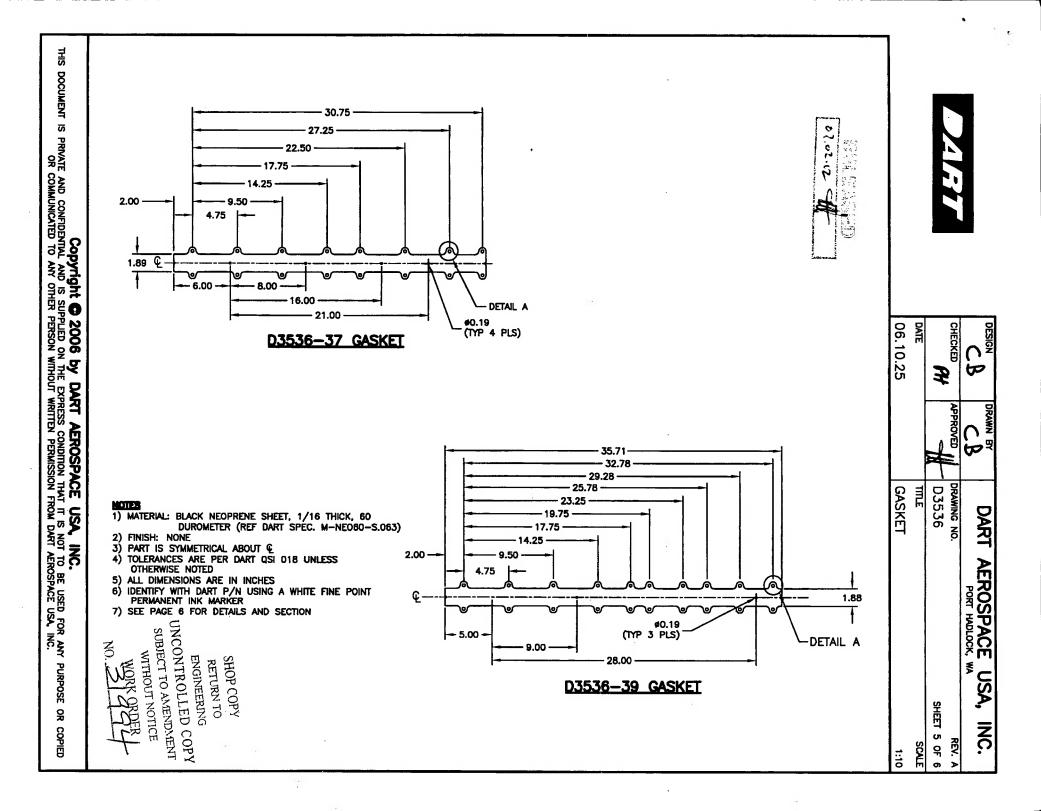
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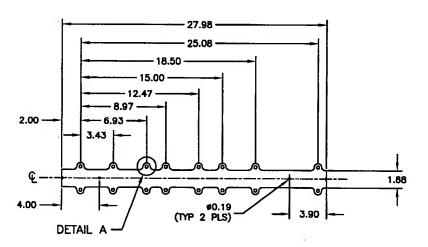
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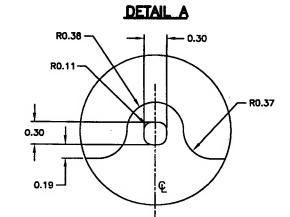
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